

Work Order ID 161426

Tuesday, May 16, 2017 6:52:00 AM

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Item ID: D3562-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Step Weldment
 Start Date: 5/16/2017 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 6/2/2017 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3562	G								
100	Large Fab	0.00							
100									
Large Fab	Memo	2.64							
Large Fab	1-Cut D2622 extrusion as per Dwg D3562 2-Debur and bevel ends for welding								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Chemical Conversion Coat per QSI005 4.1	0.00							
120									
HandFinish	Memo	1.13							
Hand Finishing									

4 DC 2017-05-18

4 38 9-00
 MAY 24 2017

(X4) Q 2017/05/30
 BFB

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC7-Inspect Chemical Conversion Coat	0.00				4			DAS 24 9-89
130									
QC	Memo	0.04							

Quality Control

140	Small Fab	0.00				4			DAS 24 9-89
140									
Small Fab	Small Fab								
Small Fab	Memo	3.40							
	1- Transfer drill Rivet holes as per dwg D3562.								
	2-Touch-up rivet holes with alodine as per dwg d3562								
	3-Rivet legs using Scotch-Weld as per dwg D3562.								
	*****Ensure to wipe off any excess magnobond *****								
	A/R Scotch-Weld DP460								
	Batch: 136223								
	EXP DATE: 4/17								

D.M.L

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.08				<u>4</u>			DAS 38 JUN 21 2017
190 *190* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.64				(x4)			2017/06/22 BEB
200 *200* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M137176 Memo START TIME: 10:45 OVEN TEMPERATURE: 300 FINISH TIME: 11:15	0.00 1.23				H			17-06-28 DAS 34 9-89

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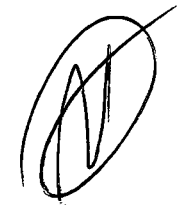
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Item ID: D3562-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Step Weldment
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Required Date: 6/2/2017 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	QC21- Final Inspection - Work Order Release	0.00							
240									
QC	Memo	0.40							
Quality Control									



JUL 11 2017

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D3562-041

Start Date: 5/16/2017

Required Date: 6/2/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-11-09 JLM
 IPP rev B ECN 987 07.10.09 EC verified by: DD
 IPP Rev:C ECN1048 07-12-18 DD verified by:ec
 IPP Rev:D 08-07-28 add chemical conversion coat DD verf:EC IPP REV:E
 13.06.03 PER DWG REV.F DD VERF:JLM IPP REV:F 16.06.23
 AS PER DWG REV.G DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C		Manufactured	No			100	Each	121.5000	1	4			
D2622-120C													
Step Extrusion													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA003		121.5	B157441	→	4x				
				152316		18.5							
				157441		103							
D2734		Manufactured	No			140	Each	39.0000	2	8			
D2734													
Step End Plate													
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				WA003		39	B161519	→	8x				
				156811		19							
				159746		20							
D3560-041		Manufactured	No			140	Each	0.0000	1	4			
D3560-041													
Arm Weldment													
D3560-043		Manufactured	No			140	Each	0.0000	1	4			
D3560-043													
Arm Weldment													

Picklist Print

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Work Order ID: 161426

Parent Item: D3562-041

Parent Item Name: Step Weldment

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D3562-041

Start Date: 5/16/2017

Required Date: 6/2/2017

Start Qty: 4.00

Required Qty: 4.00

MS20600-AD4W4

Purchased

No

140

Each

1,522.000

32

128

MS20600-AD4W4

Rivet

2017-06-08

Location

Loc Qty

Loc Code

CCK004

1011

M135704

11

M137412

1000

ST308

46

M137075

46

WA003

465

M135442

204

M136986

108

M137075

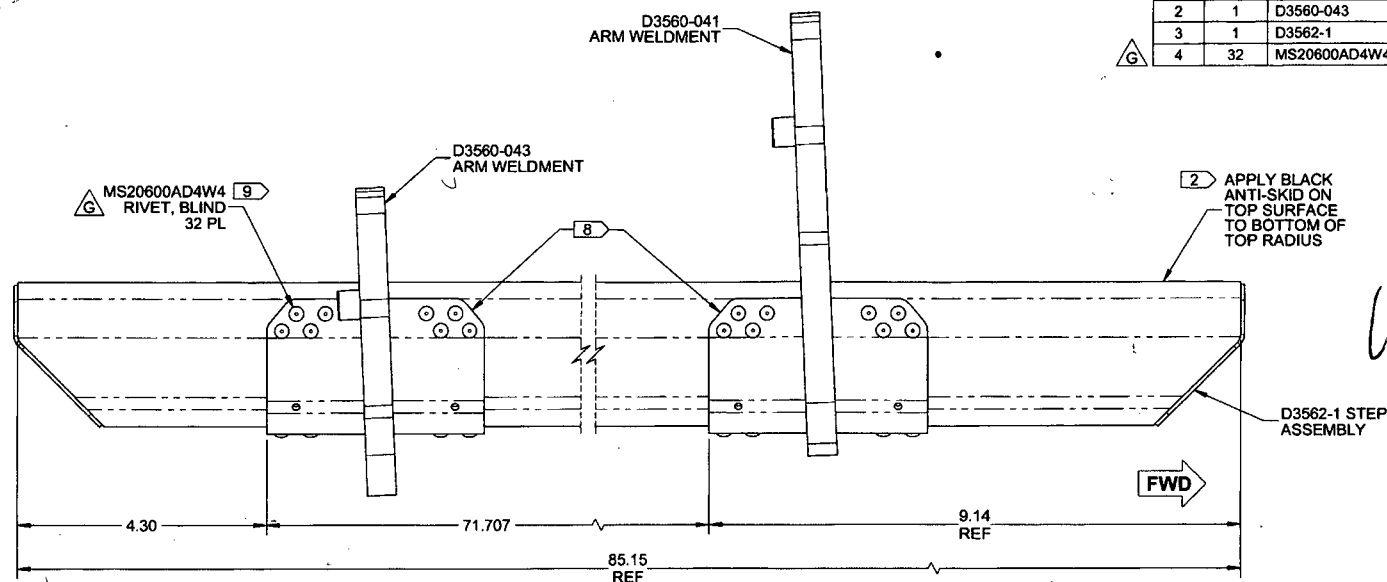
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Shop Packet Print

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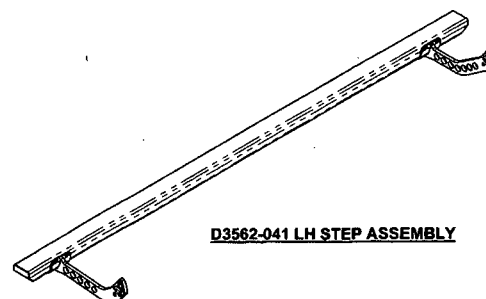
ITEM	QTY -041	P/N	DESCRIPTION
	X	D3562-041	LH STEP ASSEMBLY
1	1	D3560-041	ARM WELDMENT
2	1	D3560-043	ARM WELDMENT
3	1	D3562-1	STEP ASSEMBLY
4	32	MS20600AD4W4	RIVET, BLIND



MEASURED BEFORE END CAPS WELDED IN PLACE

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH:
 - i) POWDER COAT ASSEMBLY:
 - GLOSS WHITE (4.3.5.1) OR
 - GREY SANDETEX (4.3.5.6) OR
 - BLACK SANDETEX (4.3.5.7) OR
 - GREEN SANDETEX (4.3.5.8) PER DART QSI 005 4.3
 - ii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.80 lbs
- 8) INSTALL ARM WELDMENTS WITH A LAYER OF SCOTCH-WELD DP460 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH SCOTCH-WELD DP460. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 9) TRANSFER DRILL #30 DEBURR & TOUCH UP HOLES WITH CHEMICAL CONVERSION COAT BEFORE RIVETING



D3562-041 LH STEP ASSEMBLY

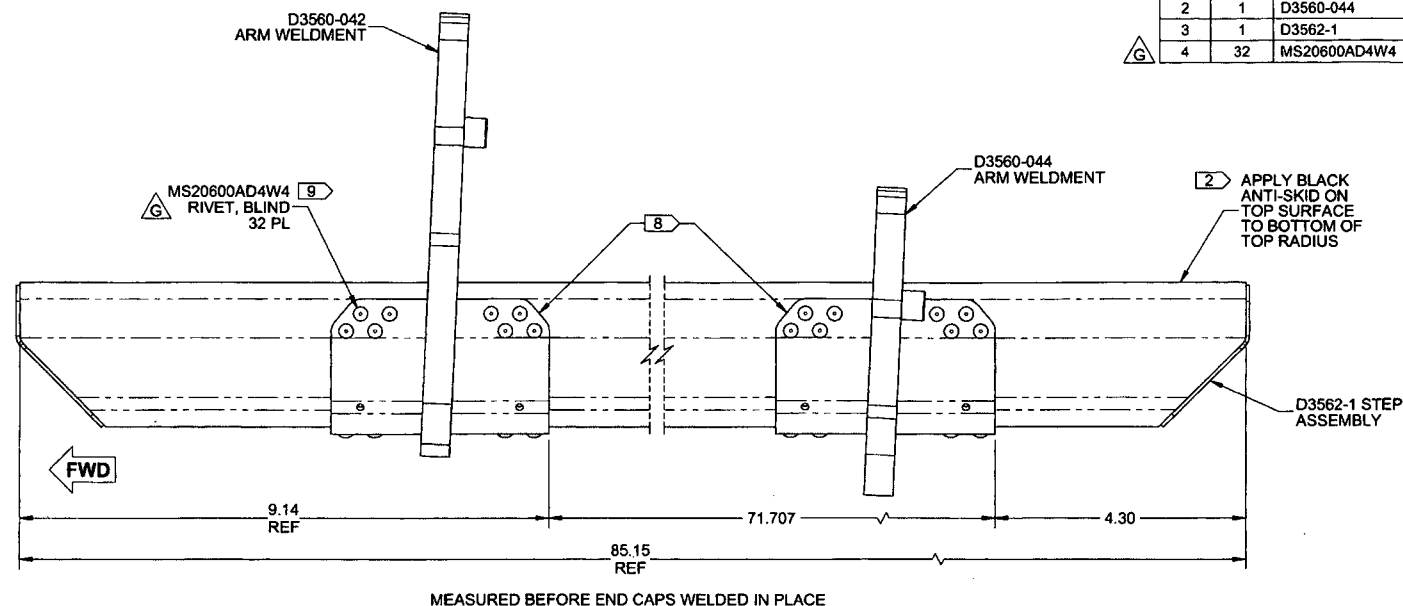
RELEASED

2016 JUN 22
EN 16-60

G	MS20600AD4W4 WAS MS20600AD4W5. REF. PAR16-517.	MB	16.04.21
F	REVISED NOTE 8 TO REMOVE MAGNOBOND, REPLACE WITH SCOTCH-WELD DP460, REF. PAR12-224. ADDED NOTE 9 AND SHEET 2	DW	13.05.15
E	ADD QTY(2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAW IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	MB		
CHECKED	ML	DRAWING NO.	REV. G
MFG. APPR.	DD	D3562	SHEET 1 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STEP ASSEMBLY	NTS
DATE	16.04.21	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND IS SUPPLIED ON THE EXPRESS ORDER THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

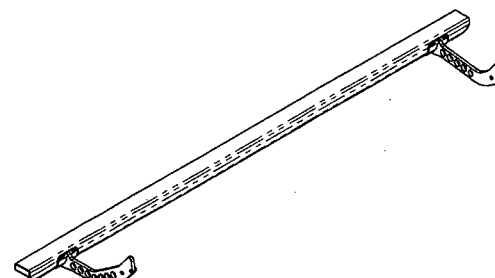
APPROVED

ITEM	QTY	P/N	DESCRIPTION
	X	D3562-042	RH STEP WELDMENT
1	1	D3560-042	ARM WELDMENT
2	1	D3560-044	ARM WELDMENT
3	1	D3562-1	STEP ASSEMBLY
4	32	MS20600AD4W4	RIVET, BLIND



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH:
 - i) POWDER COAT ASSEMBLY:
 - GLOSS WHITE (4.3.5.1) OR
 - GREY SANDTEX (4.3.5.6) OR
 - BLACK SANDTEX (4.3.5.7) OR
 - GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3
 - ii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.80 lbs
- 8) INSTALL ARM WELDMENTS WITH A LAYER OF SCOTCH-WELD DP460 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH SCOTCH-WELD DP460. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 9) TRANSFER DRILL #30 DEBURR & TOUCH UP HOLES WITH CHEMICAL CONVERSION COAT BEFORE RIVETING



D3562-042 RH STEP ASSEMBLY

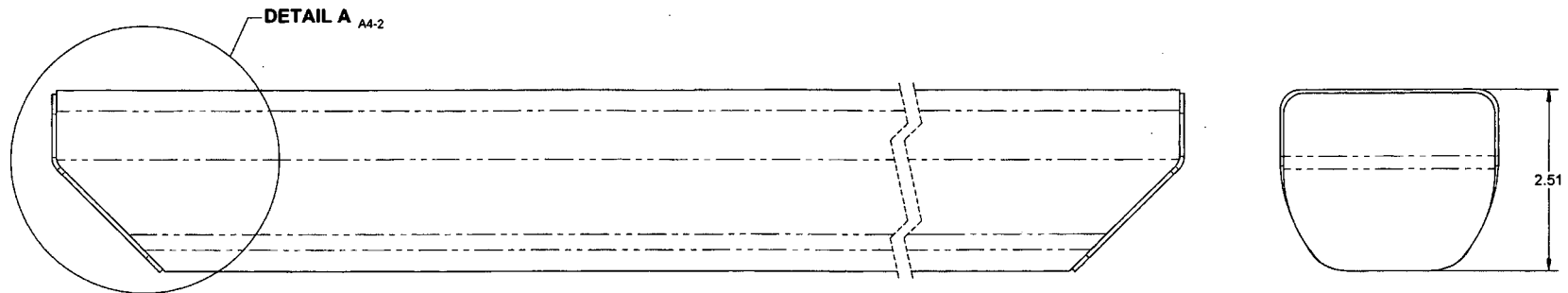
APPROVED

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. G
MFG. APPR.	DD	D3562	SHEET 2 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STEP ASSEMBLY	NTS
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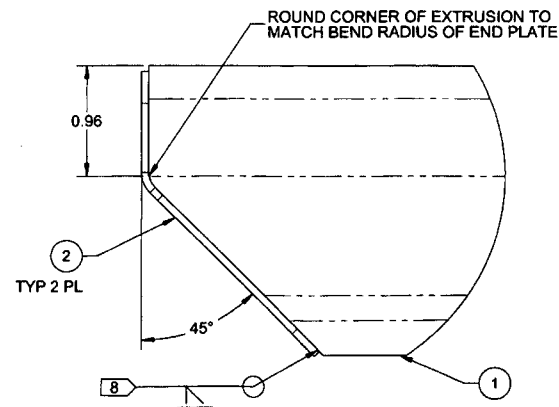
RELEASED

2016 JUN 22 *g*

ITEM	QTY	P/N	DESCRIPTION
	X	D3562-1	STEP ASSEMBLY
1	A/R	D2622-XXX	STEP EXTRUSION
2	2	D2734	END PLATE



D3562-1 STEP ASSEMBLY



DETAIL A D6-2
TYP BOTH ENDS
SCALE 1.5X

RELEASED

2016 JUN 22 *ap*

NOTES:

- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT STEP EXTRUSION
PER DART QSI 005 4.1 BEFORE ASSEMBLY
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.68 lbs
- 8) WELDING: ALL WELDS SHALL BE 100% VISUALLY INSPECTED
BY A QUALIFIED INSPECTOR PER DART QSI 004

APPROVED

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. G
MFG. APPR.	DD	D3562	SHEET 3 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STEP ASSEMBLY	NTS
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